

Date: Wednesday, 1/30/2008 8:02:45 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOOR PROTCTOR RH		
Job Number	37105		Part Number	D32803		
Estimate Number	11225		Drawing Number	D3280 REV B		
P.O. Number	:		Project Number	N/A		
This Issue	1/30/2008	S.O. No. :	Drawing Revision	B		
Prsht Rev.	NC		Material	:		
First Issue	1/1	Type : THERMOFORMING	Due Date	2/8/2008	Qty:	5
Previous Run	35946		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	Est Rev:A 04.07.01 New issue KJ/JLM Est RevB 07.09.12 Thermoform in house DL					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	F6006 701	lexan black
Comment: Qty.: 4.0000 sf(s)/Unit Total : 20.0000 sf(s) lexan black		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING M106 995 1) Cut Blanks BB 08/02/08 X5		
3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D32811and Folio FTA 012 BB 08/02/08 X5		
Dwg. Rev. <u>C</u> Folio Rev. <u>0</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE BB 08/02/08 X5		
5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING BB 08/02/11 X1		
1) Trim to Finished Dimensions BB 08/02/11 X4		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 8:02:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR RH

Job Number: 37105

Part Number: D32803

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB

08/02/11

(X5)

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/13 (X5)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST267

AS 08/02/13 (X5)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/14 (5)

Job Completion



min 2008/2/13

5

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37105
Description: R22 Floor Protector, RH	Part Number:	D3280-3
Inspection Dwg: D3280	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/02/11

TRIMMING SECTION

Measured by: BB

Date: 08/02/11

Audited by: ✓ ~~as~~

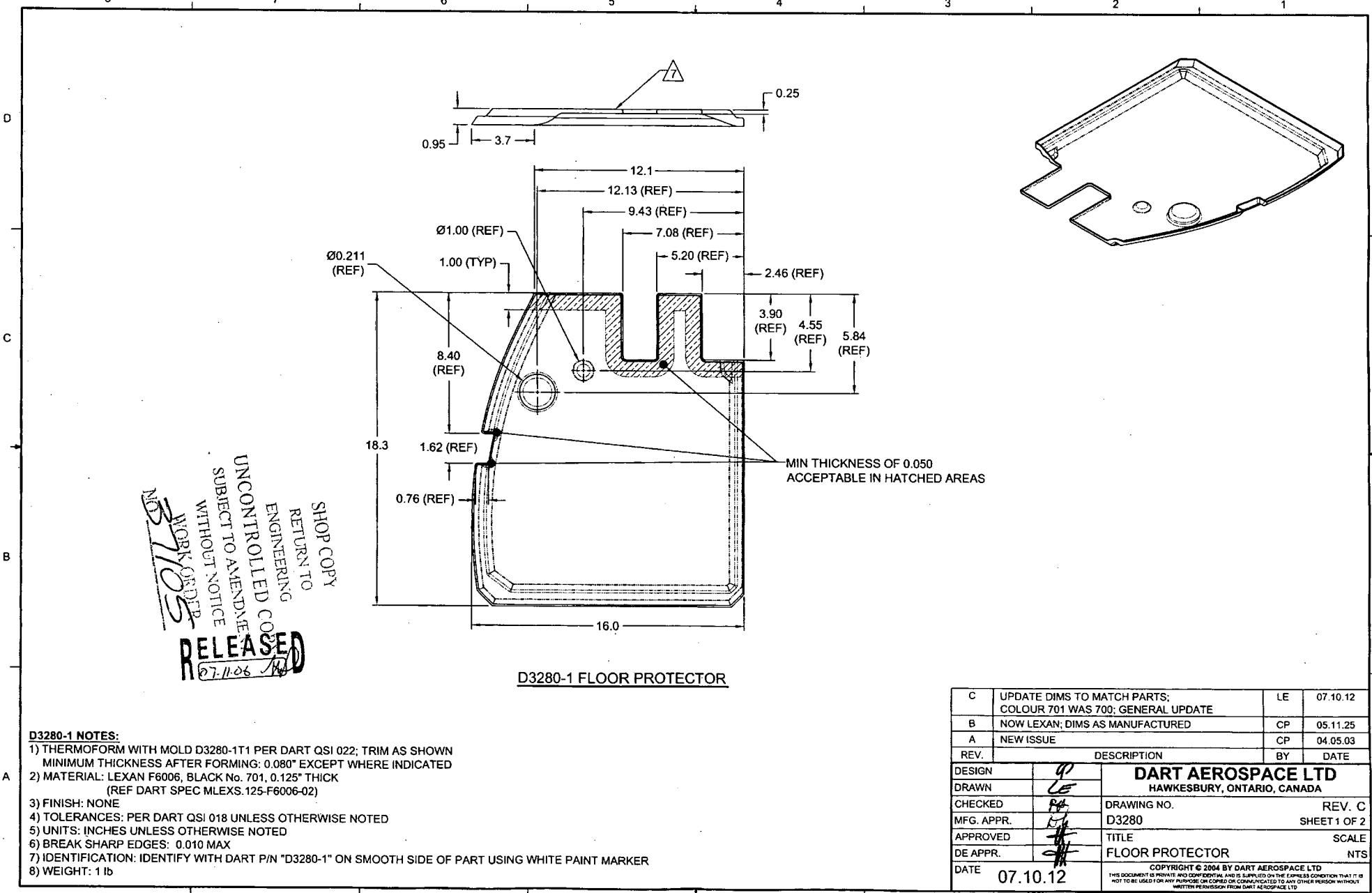
Date: 08/02/11

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	

8 7 6 5 4 3 2 1



D3280-1 NOTES:

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	ME	D3280	SHEET 1 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	FLOOR PROTECTOR	NTS
DATE	07.10.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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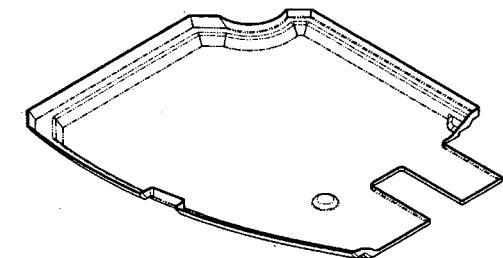
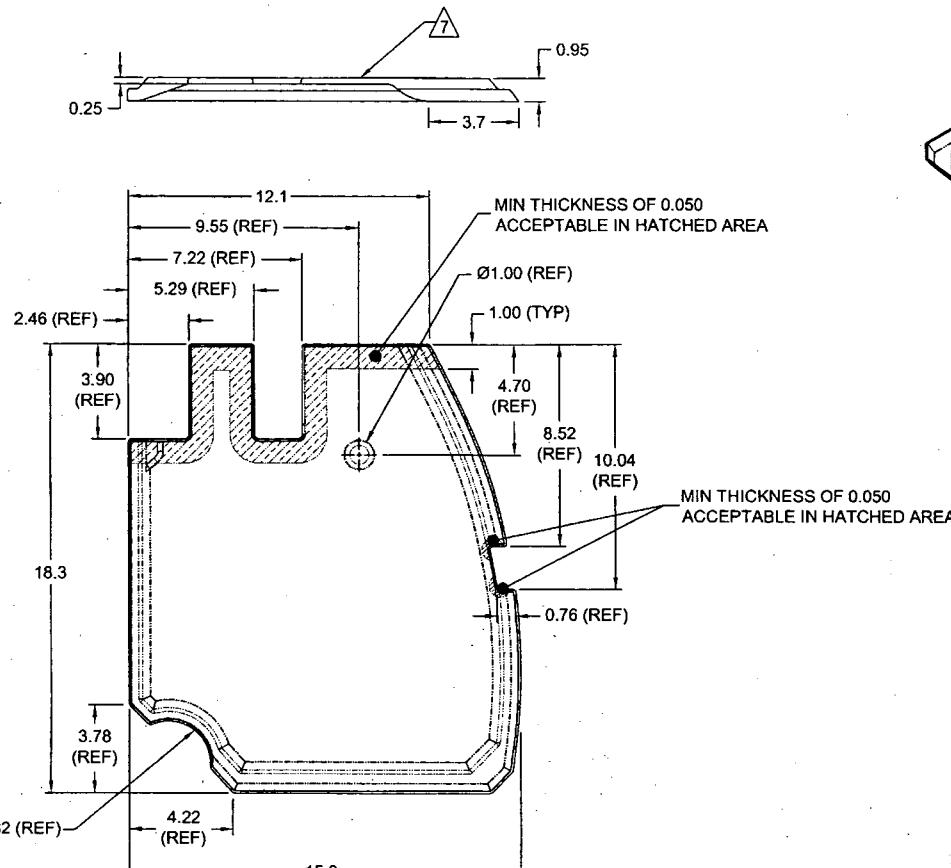
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C

B

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8 7 6 5 4 3 2 1



137105
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 WORK ORDER
 WITHOUT NOTICE

RELEASED
07/10/06

D3280-3 FLOOR PROTECTOR

D3280-3 NOTES:

- 1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	91	DART AEROSPACE LTD	
DRAWN	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BB	DRAWING NO. D3280	
MFG. APPR.	BB	REV. C SHEET 2 OF 2	
APPROVED	BB	TITLE FLOOR PROTECTOR	
DE APPR.	BB	SCALE NTS	
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